



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3201-4
Job Sheet 186938



Part No: D3201-4

Job Qty: 6 ea

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/22/18

Job Tracking No:

Due Date: 12/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A Removed from 9 Digit 06-01-25 JLM IPP Rev: B Now on Waterjet 06-08-14 JLM IPP Rev: C Added scribing, NCR262 07.11.29 EC IPP Rev: D 10.10.29 remove scribe b# & p# DD ver: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs	12/3/18	12/3/18	0.00	0.14	Waterjet - Flow		SC 5/11/29
120	QC	6 pcs	12/3/18	12/3/18	0.00	0.00	QC8		38
140	Brake NC	6 pcs	12/3/18	12/3/18	0.09	0.13	Brake NC 1		DAS 30
150	QC	6 pcs	12/3/18	12/3/18	0.00	0.00	QC5		38
160	HandFinish	6 pcs	12/3/18	12/3/18	0.00	0.17	HandFinish1		D.R. 12/12/19
170	QC	6 pcs	12/3/18	12/3/18	0.00	0.00	QC7-2		38
180	Packaging	6 pcs	12/3/18	12/3/18	0.00	0.00	Packaging3-1	57023	38
190	QC21-SA	6 Ea	12/3/18	12/3/18	0.00	0.00	QC21		DAS 38
Part Op 100 - 1-Cut as per Dwg D3201 (CHECK GRAIN DIRECTION BEFORE CUTTING) Descriptions: 140 - 1-Bend as per Dwg D3201									21 DEC 2 1 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	.2700 sf (.045 ea)	100-Waterjet - Flow - 1	M137626

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	0	34	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	3.760inches $\pm$ 0.030	3.790 3.730	3.761	
2	Doubler	3.460inches $\pm$ 0.030	3.490 3.430	3.462	
3	Doubler	1.680inches $\pm$ 0.030	1.710 1.650	1.683	
4	Doubler	0.050inches $\pm$ 0.010	0.060 0.040	0.050	

QA Closed: _____ Date: _____

Work Order update only



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
		Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
NCR No. _____		Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
		Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		
Date :	Step #:	QTY Effective :							MRB (QSI042) Approval		
Description Work Order Deviation											
DART AEROSPACE Container No: S133311 Part: D3201 - 4 Job No: 186938 Serial No/Batch: S133311 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 11/29/18 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com											
Root Cause											
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Wrong	☐				
Design	☐	Operator	☐	Bending	☐	Dimensions	☐				
Doc/Data	☐	Offset/Setup	☐	Centre Not Conc	☐	Tolerance	☐				
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Defect	☐				
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Missing	☐				
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐				
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐				
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐				
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐				
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐				
Past Expiry Date	☐	Manufacturing Process	☐	Drill Holes	☐	Part Moved	☐				
Misidentified	☐	Past Due	☐	OTHER :	☐	Drawing	☐				
					☐	Finish	☐				
					☐	Misread	☐				
					☐	Turning Sequence	☐				